



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3643-2

Job Sheet 171372



Part No: D3643-2

Job Qty: 8 ea

Part Name: Stiffener



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/31/18

Job Tracking No:

Due Date: 1/31/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV A IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea		1/30/18	0.00	0.00	Start Up Waterjet		<i>a 18/02/02</i>
100	Waterjet	8 pcs		1/30/18	0.00	0.41	Waterjet1		<i>a 18/02/02</i>
110	QC	8 pcs		1/30/18	0.00	0.00	QC2 Waterjet-2		<i>a 18/02/02</i>
120	QC	8 pcs		1/30/18	0.00	0.00	QC8-3		<i>38</i>
130	Brake NC	8 pcs		1/30/18	0.00	0.23	Brake NC 2		<i>9-89</i>
140	Small Fab	8 pcs		1/30/18	0.00	0.32	Small Fab-4		
150	QC	8 pcs		1/30/18	0.00	0.00	QC5		
160	HandFinish	8 pcs		1/31/18	0.00	0.37	HandFinish1		
170	QC	8 pcs		1/31/18	0.00	0.00	QC7-2		
180	Packaging	8 pcs		1/31/18	0.00	0.00	Packaging3-1		
190	QC21-SA	8 Ea		1/31/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut as per Dwg D3643 Dwg Rev: *A* Prog Rev: *A* 2-Deburr if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Form as per Dwg D3643

140 - C'sink as per Dwg D3643

150 - QC5- Inspect part completeness to step on W/O

160 - Chemical Conversion Coat per QSI005 4.1

170 - QC7-Inspect Chemical Conversion Coat

180 - Identify as per dwg & Stock Location:

190 - QC21- Final Inspection - Work Order Release

Job BOM

Job BOM records could not be found.

DAS
10
9-89

M2024 T3S.040

1558

Job Allocations

Job Allocations could not be found.

Part Specifications

Specifications could not be found.

Plex 1/31/18 11:43 AM Dart.Gagnon.Michelle

Change No:
Operation:
Revision:
Original Serial #:
PART NO:

D3643-2
Start up Operation

Job No: 171372
02/02/18



Stiffener

DART
AEROSPACE
S038361

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DQA: _____ Date: _____

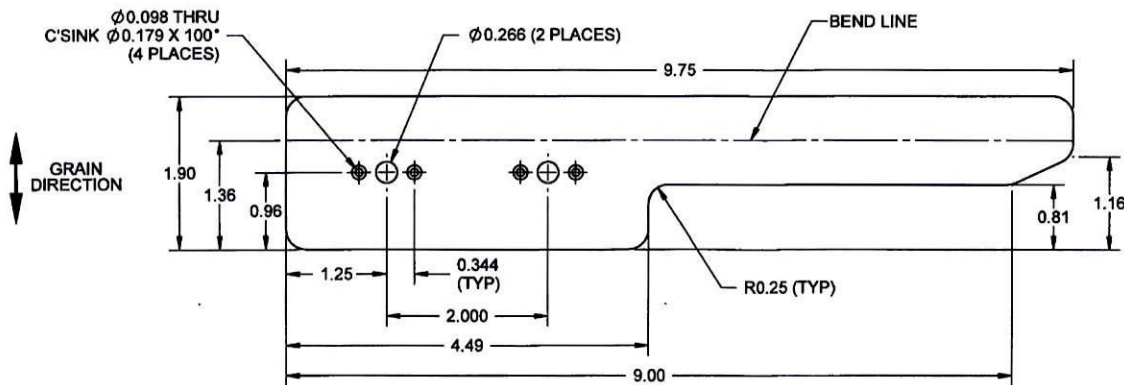
WORK ORDER NON-CONFORMANCE / UPDATE



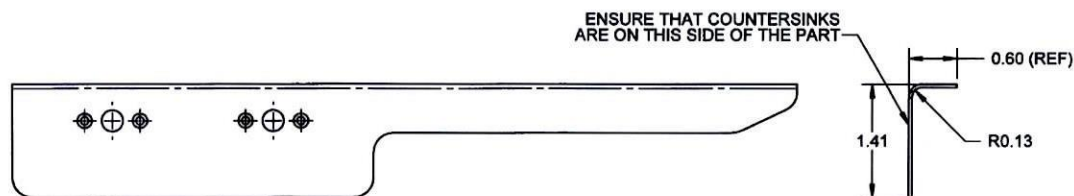
QA Closed: _____ Date: _____

Work Order update only ☐

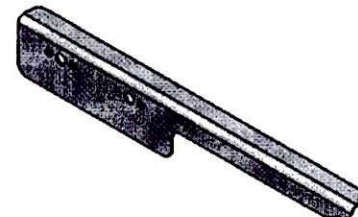
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



D3643-1F FLAT PATTERN
(D3643-2F OPPOSITE)



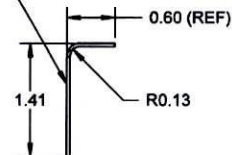
D3643-1 STIFFENER (REPLACES GENEVA P/N G10610-2)
D3643-2 OPPOSITE (REPLACES GENEVA P/N G10610-1)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 171372

JAN 31 2018

ENSURE THAT COUNTERSINKS
ARE ON THIS SIDE OF THE PART



RELEASED
07.09.07

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3643-1/-2" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.06 lbs

A	NEW ISSUE; REPLACES G10610	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DT		
DRAWN	DT		
CHECKED	DT		
MFG. APPR.	DT		
APPROVED	DT		
DE APPR.	DT		
DATE	07.07.27		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3643 TITLE STIFFENER COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			
REV. A		SHEET 1 OF 1	
SCALE		2:3	